

Work Order ID 80045

80045

Page 1

Thursday, February 09, 2012 11:21:11 AM

Item ID: D4055-9

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Tank Back

Stop *NS2*

Start Date: 2/10/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

mk

Date:

12-02-09

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: *16457*
Purchase part as per Dwg D4055
Possible Supplier: GFI
Material release note required

12-02-9
(4)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

6/2/3/5 *(4)*

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

5/2/3/07

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 2/10/2012 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

4 0 M 12/03/07

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

H BR 12 3-7

150

Identify as per dwg & Stock Location: WPA

0.00

150

Packaging

Memo

0.00

Packaging

M 12-03-09 4 0

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, February 09, 2012 11:21:11 AM

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 Revision ID: Stop *NS2*
 Item Name: Tank Back
 Start Date: 2/10/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/24/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/3/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, February 09, 2012 11:21:11 AM

Page 1

Work Order ID: 80045

Parent Item: D4055-9

Parent Item Name: Tank Back

Start Date: 2/10/2012

Required Date: 2/24/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-9P Tank Back		Purchased	No			110	Each	0.0000	1	4		2/13/12	Y

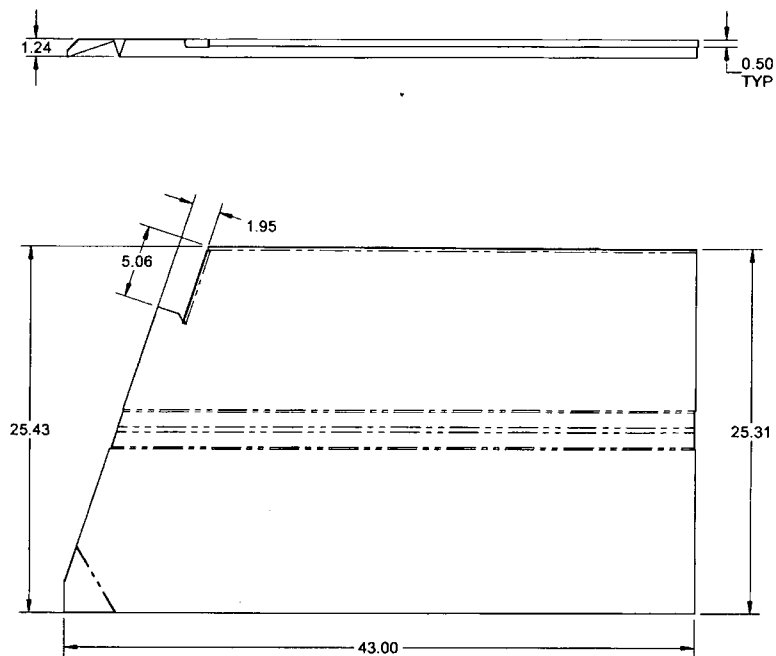
W/O:		WORK ORDER CHANGES					
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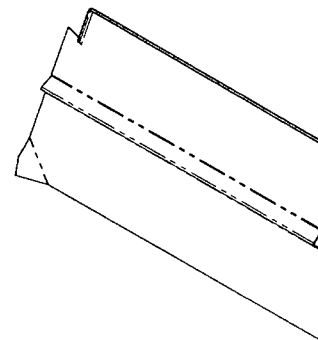
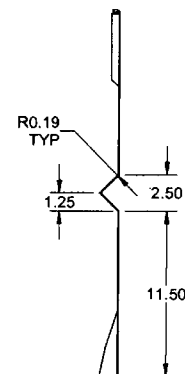
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NOTE: Date & initial all entries



D4055-9 TANK BACK



80045

RELEASED
2011-05-30
JND

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 12 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

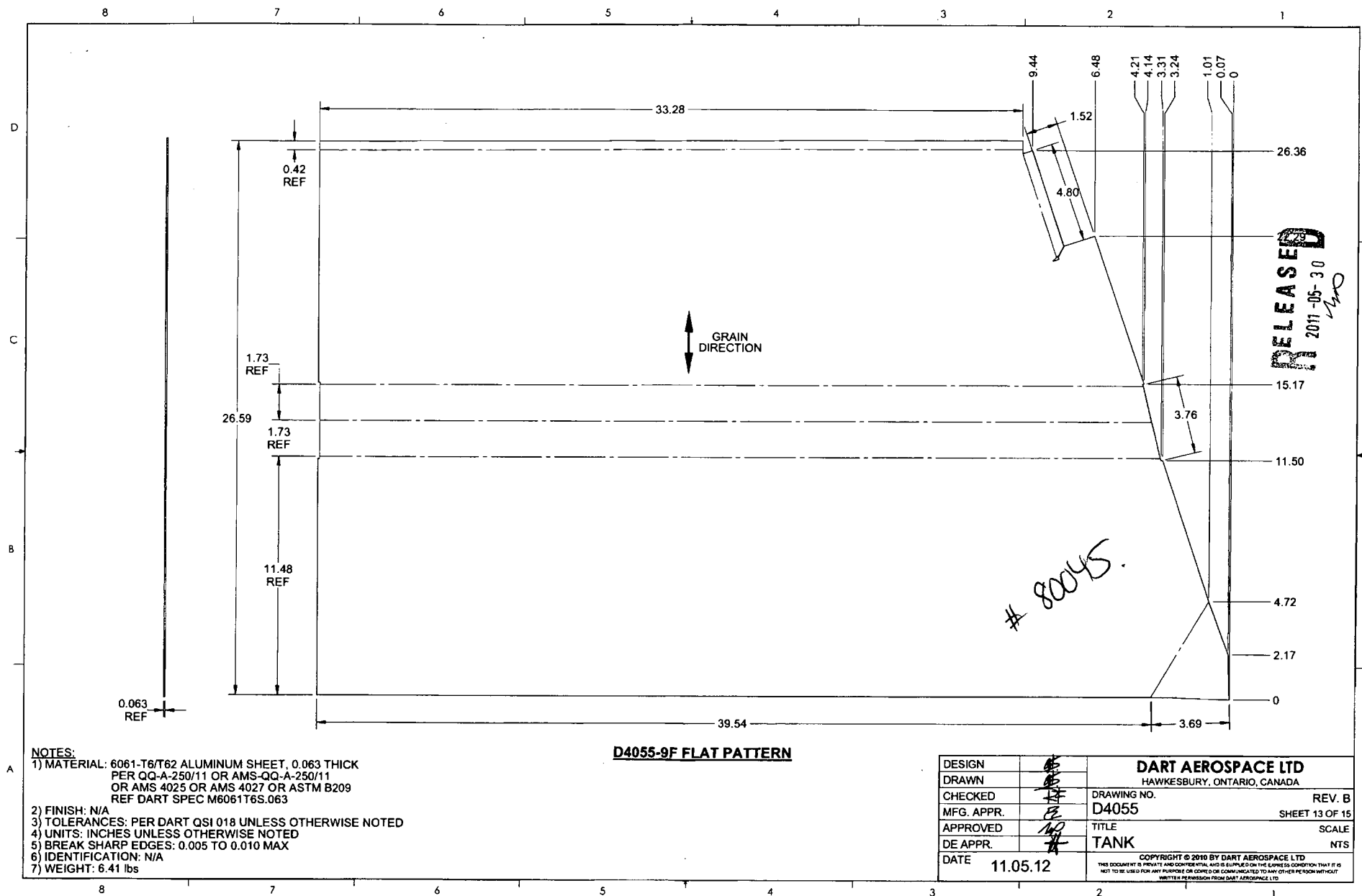
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TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. <u>7</u>		OUR JOB NO <u>J0245061</u>		SHIPPING MEMO <u>0482099</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>--</u>	<u>4 PCS</u>	<u>PO16157</u>	<u>D4055-9P</u>	<u>B</u>	<u>TANK BACK</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>.063 THK AL 6061-T6 (AMS-QQ-A-250/11)</u>		<u>SAMUEL / ALCOA INC</u>		<u>719924</u>	

1	PROCESS	PROCESSOR	RELEASE NOTE #
	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	REF. GFI MANUFACTURING JOB NUMBER J0245061-001 (4 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 02 MARCH 2012

G.F.I. Q.C. REP.

B.S. Sami





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: October 28, 2011

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire, Qc
Zip Code: H9R 1A1

du client: 0079443

Customer's order #:

de commande SSMQ: 105044
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	2	.063" X 48" X 144"	6061 T6	AMS-QQ-A-250/11 AMS 4027	719924

Bien à vous,
Yours truly,



CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1292289
Ship Date

0
B.L. No.

Invoice No.

Alcoa No. Item

2011-09-23

6372211

00000

1000300400-2

DCE-00400-2

P.O. No./Govt Contract No.

Customer

Alcoa Item

C63906 Ln#: 2

SAMUEL SON & CO LT G041110647R06

Page 1 of 2

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3TS QC

Item Description

0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -
.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-
209 REV 10 EXC MRK ASTMB209 REV 07
CMMP025 REV S ((MARKED)) KRAFT PAPER
INTERLEAVED MAX GROSS
SKID WGT: 4500 LB QUAN TOL +/-30 %
CQR 0222751 REV 05 CUST REQ 11-08-
06 *** W/E 11-08-20 ***

8,263/07

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	340127	719924	4033	100	PC	27592 46940
2	340135	719924	4075	100	PC	27592 46940
			8108	200		

Notes for CQR: 0222751.5

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0222751.5 -Specification Limits

Impr	Dir	UTS	TYS	EL4D
T6	Long Transv.	KSI	KSI	PCT
	Max			
	Min	42.0	35.0	10

CERTIFIED INSPECTION REPORT

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Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1292289	0		
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
2011-09-23	6372211	00000	1000300400-2
P.O. No./Govt Contract No.	Customer	Alcoa Item	DCE-00400-2
C63906 Ln#: 2	SAMUEL SON & CO LT G041110647R06		

Page 2 of 2

CQR: 0222751.5 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
Alloy 6061		Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05
Lot: 719924		Min	0.40	0.15		0.8	0.04				0.15
- Mechanical, Physical, Metallography, Quantometer Results											
Tmper		NO-->	UTS		TYS		EL4D				
Dir		Test	KSI		KSI		PCT				
T6		2	50.2		44.5		11.6				
			50.2		44.3		11.7				

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H2797021	Actuals	0.64	0.4	0.23	0.04	1.0	0.16	0.02	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States